

Slip Spt. 12

Work Order ID 106538

\*106538\*

September-05-13 3:20:41 PM

Item ID: D4450-043      Accept      \*N900040100\*      Setup Start \*NS1\*  
Revision ID:      Stop \*NS2\*  
Item Name: Arm Assembly  
Start Date: 9/05/13      Start Qty: 1.00      \*1\*      Cust Item ID:  
Required Date: 9/12/13      Req'd Qty: 1.00      \*1\*      Customer:  
Reference:

Approvals:      Process Plan: W      Date:      Tooling:      Date:      Run Start \*NR1\*  
QC:      Date:      SPC (Y/N):      Date:      Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4450	A								
100	Small Fab	0.00				1	9		FF
*100*									
Small Fab	Memo	0.00							
Small Fab	1- punch one side 2- slide parts in tube 3- punch other side 4- bend as per dwg 5- drill holes as per dwg 6- deburr and polish								
110	QC5- Inspect part completeness to step on W/O	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

DAS  
27  
B 9 10

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\*106538\*

Page 2

September-05-13 3:20:41 PM

Item ID: D4450-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Arm Assembly  
 Start Date: 9/05/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/12/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
*120*	Small Fab					1	0		FF 13-09-12
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg								
130		0.00				1			
*130*	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
140		0.00							
*140*	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

13912

SHIP

13/09/12

**Work Order ID 106538****\*106538\***

Page 3

September-05-13 3:20:41 PM

Item ID: D4450-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Arm Assembly  
Start Date: 9/05/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/12/13 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

13/9/13  
MF  
13-9-12

# Picklist Print

September-05-13 3:20:40 PM

Page 1

Work Order ID: 106538

Parent Item: D4450-043

Parent Item Name: Arm Assembly

Start Date: 9/05/13

Required Date: 9/12/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.09.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049 304 RD Tube .500 x .049W		Purchased	No			100	f	359.9887	3.49	3.6736842		FF 13-09-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		43.66							
				120633		43.66							
				MAT017		316.328716							
				119087		0.000016							
				123449		86.0547							
				125513		30.274							
				m126466		200			3.673				
D2054 Bushing - Delrin		Manufactured	No				Each	81.0000		2		FF 13-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		81							
				104846		30			2				
				87318		12							
				93250		26							
				97113		13							
D2055 Clamp		Manufactured	No				Each	42.0000		2		FF 13-09-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		42			2				
				77110		1							
				85942		11							
				92691		10							
				95397		8							
				98395		12							

# Picklist Print

September-05-13 3:20:40 PM

Page 2

Work Order ID: 106538  
Parent Item: D4450-043  
Parent Item Name: Arm Assembly

Start Date: 9/05/13

Required Date: 9/12/13

Start Qty: 1.00

Required Qty: 1.00

D2056 Manufactured No Each 34.0000  
Bell Crank Assembly

1

FF 13-09-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	34	
85943	2	
92742	12	
97798	20	

D3072-1 Manufactured No Each 7.0000  
Bracket

1

FF 13-09-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST025	7	
57252	2	
96791	5	

D3072-2 Manufactured No Each 6.0000  
Bracket

1

FF 13-09-12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST025	6	
97268	6	

September-05-13 3:20:40 PM

Shop Packet Print

Page 2

# Picklist Print

September-05-13 3:20:40 PM

Page 3

Work Order ID: 106538  
Parent Item: D4450-043  
Parent Item Name: Arm Assembly

Start Date: 9/05/13

Required Date: 9/12/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No Each 6,613.0000

3

FF 13-09-12

Location	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	331	
111668	1	
117885	32	
119017	55	
119075	138	
123265	43	
M126036	62	
ST506	1311	
123900	912	
124291	399	
ST510a	4950	
M126275	950	
M126333	4000	

3

MS27039-1-18 Purchased No Each 2,006.0000

3

FF 13-09-12

Location	Loc Qty	Loc Code
ST306	8	
121556	8	
ST516	1998	
124326	1998	

2

1

September-05-13 3:20:41 PM

Shop Packet Print

Page 3

# Picklist Print

September-05-13 3:20:41 PM

Page 4

Work Order ID: 106538  
Parent Item: D4450-043  
Parent Item Name: Arm Assembly

Start Date: 9/05/13

Required Date: 9/12/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased No

Each 7,111.0000

6

Washer

FF 13-09-12

Location

Loc Qty

Loc Code

FP001

1

123248

1

ST294

356

113068

11

122378

21

124392

324

ST510a

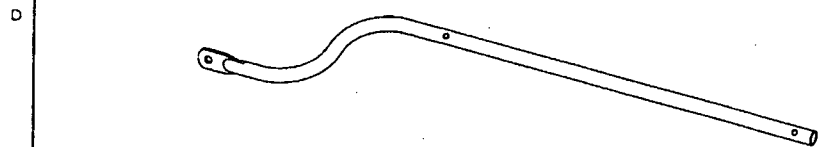
6754

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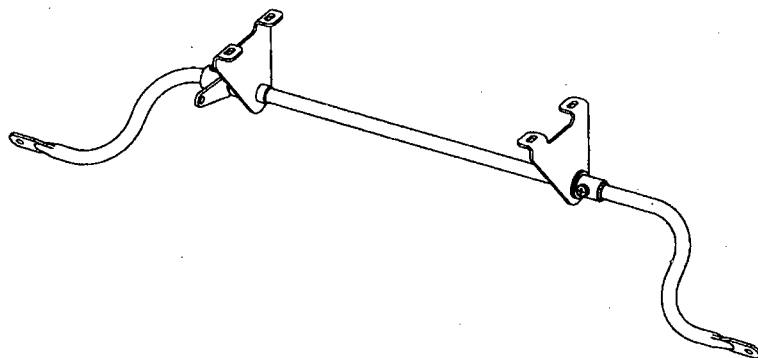
6754

3

8 7 6 5 4 3 2 1



**D4450-1 ARM**



**D4450-043 ARM**

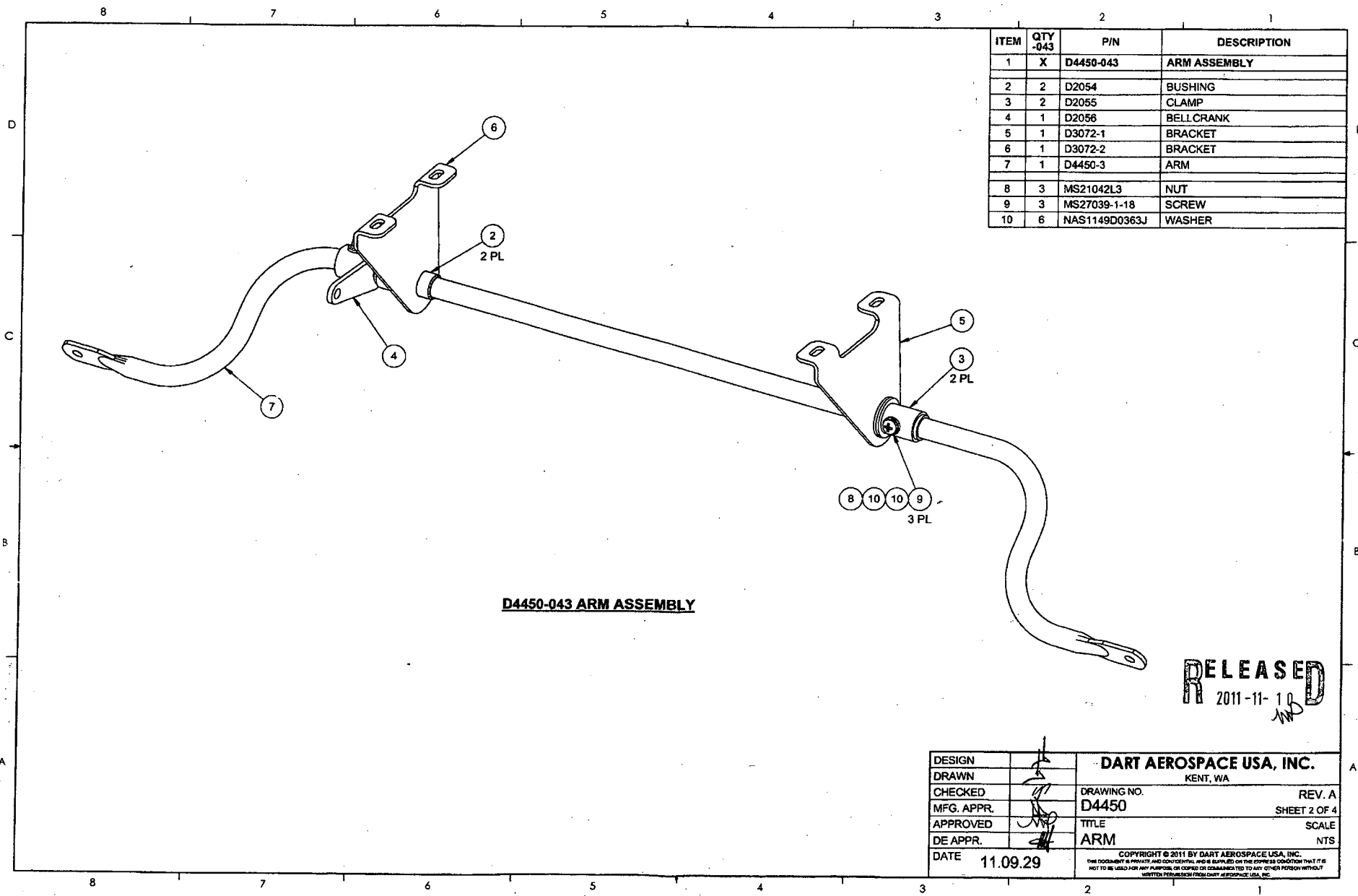
*also  
106538*

**RELEASED**  
2011-11-10  
*MD*

A	NEW ISSUE	MB	11.09.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4450</b> TITLE <b>ARM</b>	REV. A	SHEET 1 OF 4
DRAWN		SCALE	NTS
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
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8 7 6 5 4 3 2 1





**D4450-043 ARM ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4450-043	ARM ASSEMBLY
2	2	D2054	BUSHING
3	2	D2055	CLAMP
4	1	D2056	BELL CRANK
5	1	D3072-1	BRACKET
6	1	D3072-2	BRACKET
7	1	D4450-3	ARM
8	3	MS21042L3	NUT
9	3	MS27039-1-18	SCREW
10	6	NAS1149D0363J	WASHER

**RELEASED**  
2011-11-10  
JW

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4450	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
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